Work Order ID 124107

September-11-14 11:54:49 AM

124107

Item ID: D4435-043 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Mount Bracket Assembly **Stop** *NS2*

Start Date: 9/10/14 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 9/10/14 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Approvals: **Process Plan:** MLJ **Date:** 14-09-11 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4435	B								
100	FLOW WATER JET	0.00				(2)	____	Dec 17/10/24	DAS 23 9-89
100									
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut D4435-3 as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				(2)	____	Dec 17/10/24	DAS 23 9-89
110									
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				(2)	____	____	DAS 38 9-89
120									
QC	**Memo**	0.00							
Quality Control									

OCT 27 2014

DQA: _____ Date: _____

QA Closed: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D4435-043 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Mount Bracket Assembly

Start Date: 9/10/14 **Start Qty:** 2.00 *2*
Required Date: 9/10/14 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				2	0	14-10-27	
130									
HandFinish	**Memo**	0.00							
Hand Finishing									
135	QC7-Inspect Chemical Conversion Coat	0.00				2	0	14-10-29	DAS 34 9-89
135									
QC	**Memo**	0.00							
Quality Control									
140	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00				2	0	14-10-29.	DAS 34 9-89
140	M127892								
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 8:15 OVEN TEMPERATURE: 320° FINISH TIME: 845								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Work Order ID 124107

September-11-14 11:54:49 AM

124107

Item ID: D4435-043 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Mount Bracket Assembly **Stop** *NS2*

Start Date: 9/10/14 **Start Qty:** 2.00 *2*

Required Date: 9/10/14 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				(2)			DAS 38 9-89
150									
QC	**Memo**	0.00							
Quality Control									OCT 2 9 2014
160		0.00							
160									
Small Fab	**Memo**	0.00				2X	DAS 28 9-89		NOV 0 3 2014
Small Fab	1- Cut rubber seal at 3.70"								
	2-Glue rubber seal to bracket as per dwg (SHEET 1, NOTE 8)								
	M12887J								
170	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
170						(2)			
QC	**Memo**	0.00							
Quality Control									NOV 0 3 2014

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 124107

September-11-14 11:54:49 AM

124107

Item ID: D4435-043 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Mount Bracket Assembly

Start Date: 9/10/14 **Start Qty:** 2.00 *2*

Required Date: 9/10/14 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: ST107	0.00					DAS 26 9-89		NOV 04 2014
190 Packaging						24			
Packaging	**Memo**	0.00							
200	QC21- Final Inspection - Work Order Release	0.00							
200 QC									
Quality Control	**Memo**	0.00							

14/11/5

AR 9-11-04

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

September-11-14 11:54:48 AM

Work Order ID: 124107 *124107*

Parent Item: D4435-043 *D4435-043*

Parent Item Name: Mount Bracket Assembly

Start Date: 9/10/14 **Required Date:** 9/10/14

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC IPP REV:B
12.03.06 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4441-1		Manufactured	No			160	f	513.0000	0.308	0.616		DAS 28 9-89	NOV 0 3 2014
D4441-1 Rubber Seal									**				

Location	Loc Qty	Loc Code	
ST425	513		
120932	512		0.616
86185	1		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	287.6900	0.049	0.103158		DAS 23 9-89	
M6061T6S.040 6061-T6 .040 Sheet									**			DX 14/10/24	

Location	Loc Qty	Loc Code	
MAT021	287.69		
m128422	49.79		
m129584	7.9		
m129881	38		
m130312	192		.2795

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
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☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
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General

☐ Bend
☐ BOM/Route
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☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
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☐ Folio/Program
☐ Grain
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☐ Mislabeled
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☐ Off-set
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☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

DART AEROSPACE LTD	Work Order:	124107
Description: Bracket	Part Number:	D4435-3
Inspection Dwg: D4435 **Rev:** B		Page 1 of 1

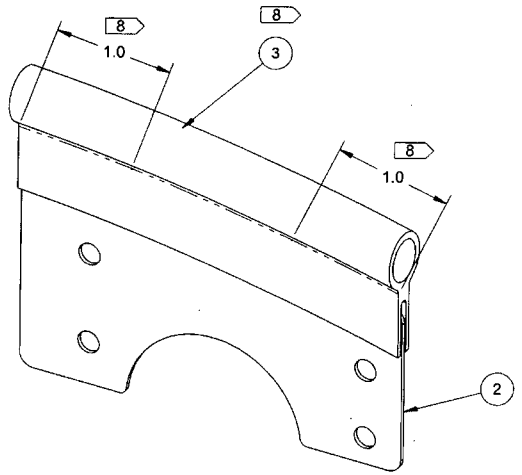
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.204	+0.005/-0.001	.205	✓		U-JKM-01	
0.850	+/-0.010	.850	✓			
0.35	+/-0.030	.35	✓			
2.650	+/-0.010	2.650	✓			
2.64	+/-0.030	2.64	✓			
3.65	+/-0.030	3.65	✓			
0.25	+/-0.030	.25	✓			
0.650	+/-0.010	.650	✓			
0.350	+/-0.010	.350	✓			
1.53	+/-0.030	1.53	✓			
2.15	+/-0.030	2.15	✓			
0.040	+/-0.010	.038	✓			
	DAS 23 9-89		DAS 38 9-89			

Measured by:	DC	Audited by:	KJ	Preliminary Approval:	
Date:	14/10/24	Date:	OCT 27 2014	Date:	

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	12.05.22	Dimensions updated per Dwg Rev B	KJ	

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4435-043	MOUNT BRACKET ASSEMBLY
2	1	D4435-3	BRACKET
3	1	D4441-1-037	RUBBER SEAL
4	A/R	3M 1300/1300L	ADHESIVE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124107 MJ
14-09-11

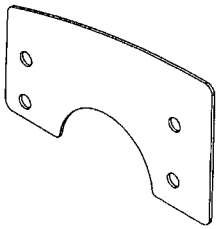
D4435-043 BRACKET ASSEMBLY

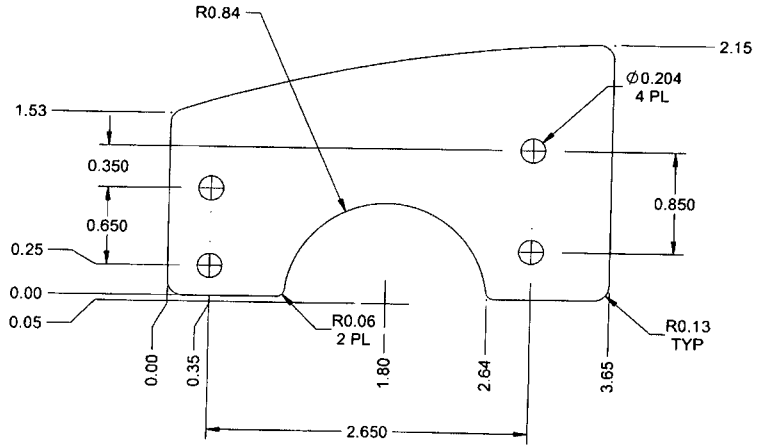
RELEASED
2012 -03- 02
JMP

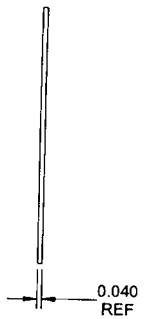
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.04 lbs
8) GLUE RUBBER SEAL TO BRACKET EDGE USING 3M 1300/1300L ADHESIVE, EXCEPT 1.0" FROM EACH END. ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	MP	DRAWING NO. D4435 REV. B SHEET 2 OF 11
MFG. APPR.	E	
APPROVED	MP	TITLE BRACKET SCALE NTS
DE APPR.		
DATE	12.01.27	

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RELEASED
2012 -03- 02

D4435-3 BRACKET

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.023 lbs

DESIGN	RF	**DART AEROSPACE LTD**
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4435 REV. B
MFG. APPR.		SHEET 5 OF 11
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	12.01.27	

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